

Date: Wednesday, 9/13/2006 4:21:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 STEP ASSEMBLY, SHORT HIGH SKID
Job Number : 28509	
Estimate Number : 10460	
P.O. Number : N/A	Part Number : D350591113
This Issue : 9/13/2006 S.O. No. : N/A	Drawing Number : D2310 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : D
Previous Run : 27735	Material : N/A
Written By : _____	Due Date : 10/10/2006 Qty: 4 Um: Each
Checked & Approved By : <u>06.09.14</u>	
Comment : Est Rev: H 04.11.09 Reformat KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-591-113 CHG003

KJ 06.09.20

2.0	D2244116	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2244	Step Extrusion	3 23404

P.E. 06.09.28 4

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

3-Deburr

P.E. 06.09.28 4

P.E. 06.09.29 4

P.E. 06.09.29 4

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

P.E. 06.09.29 4

5.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

P.E. 06.09.30 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 28509

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2673-34

End Cap

325396

PE. 06.9.30

4

6.0

D2275

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2275

Bushing

312557

PE. 06.9.30

4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R AL ROD

Batch: M15629 M19612

PE. 06.9.30

4

2-Grind end cap and bottom bushing welds flush

PE. 06.10.02

4

3-Machine top weld on bushing flush

PE. 06.10.02

4

8.0

QC5/9

WELD INSPECTION



Comment: WELD/WORK INSPECTION

206.10.03 (4)

206/10/04 (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 06/10/09 (4)

10.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part number Description

Batch

16 MS20600AD4W3 Rivet

M101519 = 18

M101415 = 47

PE. 06.10.18

4

11.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description

Batch

1 D2582

Step Leg Assembly

327756

PE. 06.10.18

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 28509

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet as per Dwg D2310

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: M19612 M18838

4-Grind end cap welds flush

LE 06-10-18

LE 06-10-18

LE 06-10-18

LE 06-10-18

13.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

26-10-20

12/06/10/18 (4)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FC 06 10 24

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

Y 06/10/24 x (4)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2310 and QSI 005 4.4

Batch: 102098

FC 06 10 25

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

FC 06/10/25 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/18/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 28509

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

K591113

Short Step Inst'n Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick Packing Kit:

Qty Part number

Description Batch

1 K591-113

Hardware Kit

B28535

PO 06/10/25

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PO 06/10/25

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-113

Location: IT

~~IT~~ PO

PO 06/10/25

22.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

PO 06/10/25

Job Completion



LO 06/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28509

RELEASED
05.11.28 [Signature]

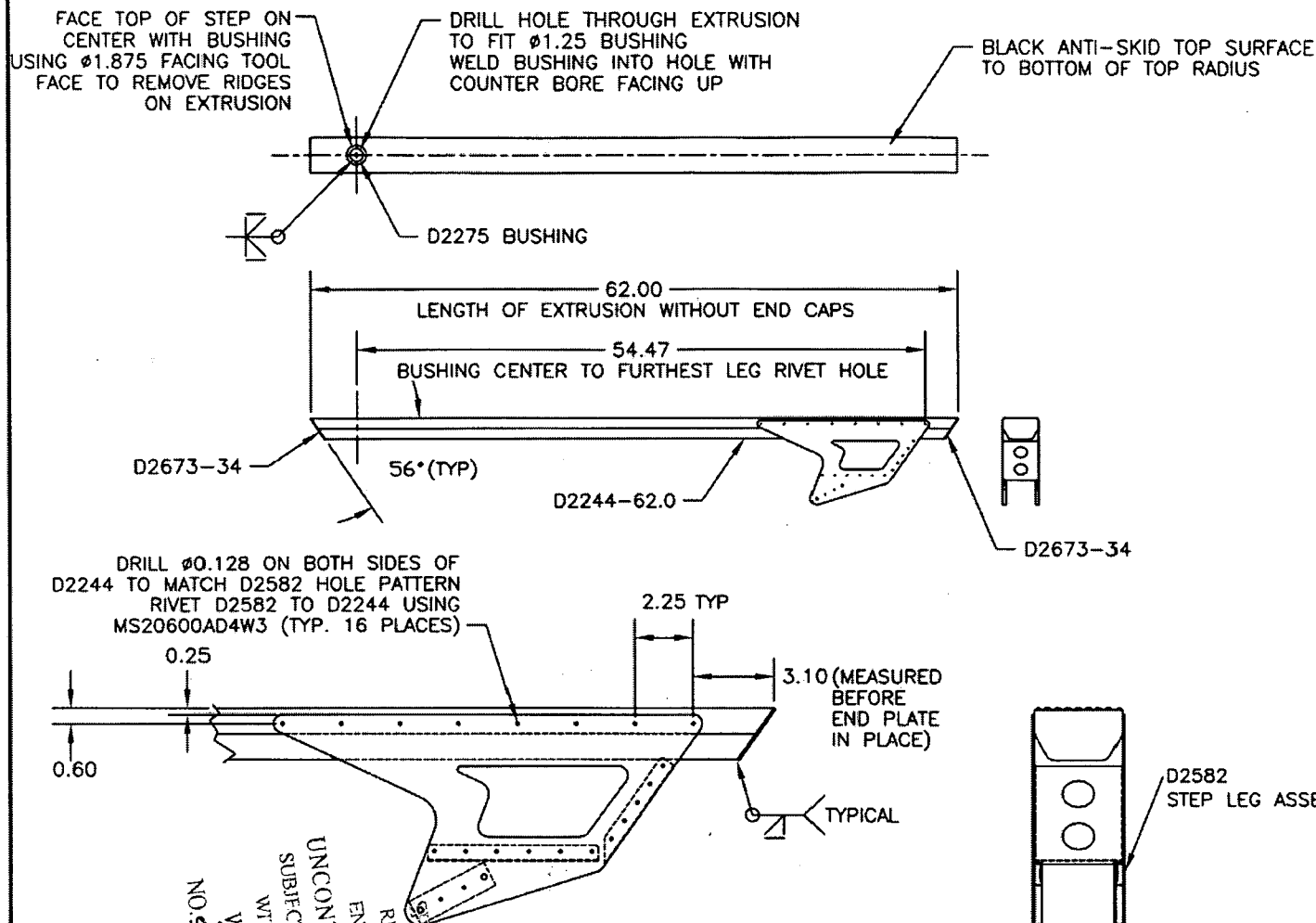
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DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE LTD	REV. D
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	D2310	SHEET 2 OF 2
DATE	05.11.14	TITLE	HIGH SHORT STEP ASSEMBLY	SCALE	NIS

HAWKESBURY, ONTARIO, CANADA



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28